

Date: Tuesday, 10/23/2007 3:10:26 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 35321	
Estimate Number : 12424	
P.O. Number :	Part Number : D2000109
This Issue : 10/23/2007 S.O. No. :	Drawing Number : D2000-109 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 27400	Material :
Written By :	Due Date : 11/15/2007 Qty: 10 Um: Each
Checked & Approved By : <u>107-10-23</u>	
Comment : Est Rev:A New Issue 06-05-31 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4889 For D2000-109

Spin as per Dwg D2000-109

Possible Supplier: SIEG

Material release note is required

107110124 (10)

2.0	D2000109S	Aspirator- Outer Flange
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

7/11/07 SD 10X

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

107110124 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Drill as per Dwg D2000

Deburr

FF 08-05-21(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:10:26 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 35321

Part Number: D2000109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/21 (410)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 162

8/5/21

(10x)

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



MF 08-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

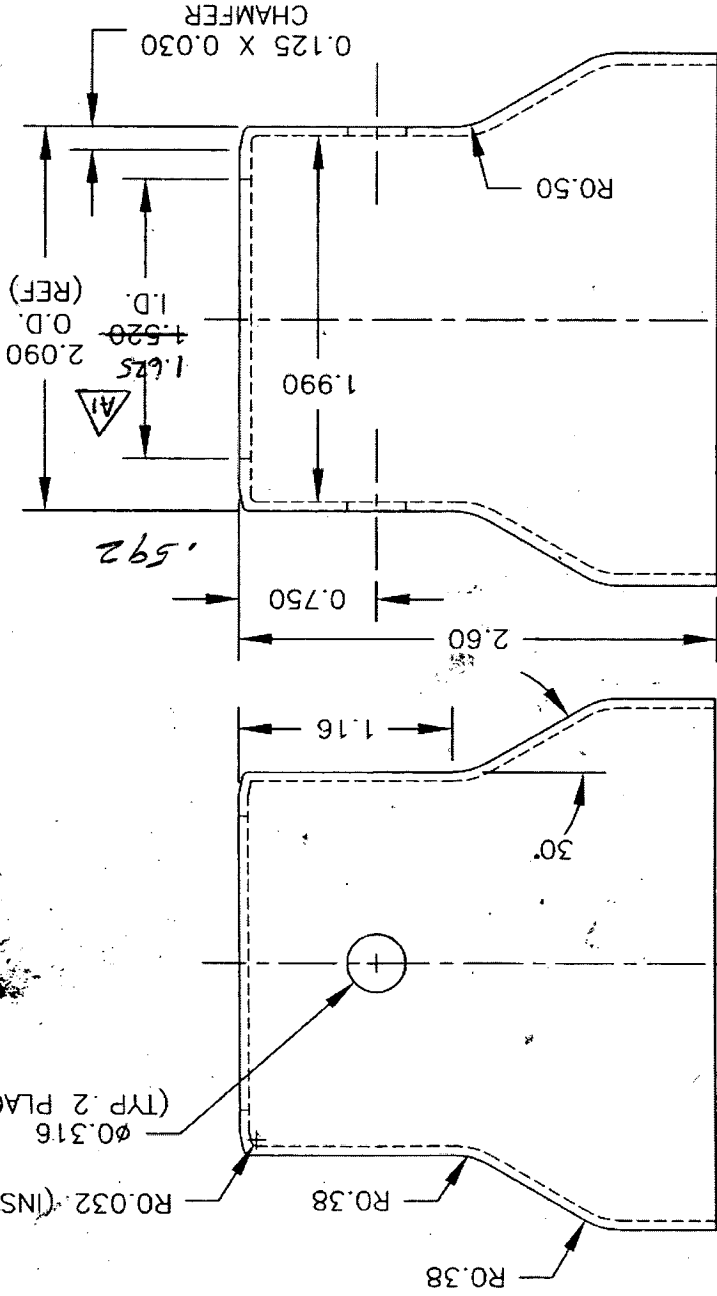


**DART**

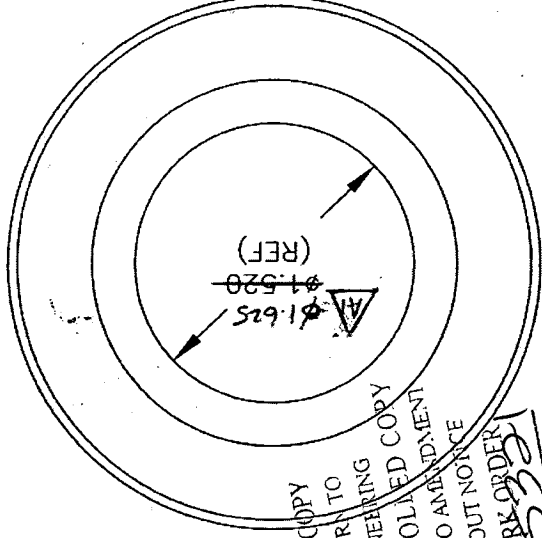
DESIGN	JB	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	CP	APPROVED	CP	HAWKESBURY, ONTARIO, CANADA
DATE	00.11.13	DRAWING NO.	D2000-109	REV. A
		TITLE	ASPIRATOR	SHEET 1 OF 1
		SCALE	1:1	
A	00.11.13	AS MANUFACTURED		
A1	01.10.01	1.625 WKS 1.520		

Ø0.316 (TYP. 2 PLACES)  
R0.032 (INSIDE)  
R0.38  
R0.38

CP



NOTES:  
THIS PART MUST MATE WITH D2000-111  
MATERIAL: 1100-0 ALUMINUM (00-A-250/1) 0.063 THICK  
FINISH: NONE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**RELEASED**  
00 11 13

SHOP COPY  
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ENGINEERING  
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WITHOUT NOTICE  
WORK ORDER  
NO. 223321

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W.H. GERRY



ALCOA INHERIT PRODUCTS  
1480 Manheim Pike  
Lancaster Pa 17601

# Certification of Test Results

P/N 970200

PO 38C880

SOLD TO	SHIP TO

CERT NO 0000575996  
DATE 4/23/2007  
SKID NO 661031  
SKID WGT 9,885  
PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756	MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO		
ALLOY	1100	TEMPER	O	
GAUGE	05300	WIDTH	48.0000	
		FORM	COIL	
		LENGTH	0.0000	

LOT: 334171 COIL: B01 DROP: 0710187

INGOT	SI	FE	CU	NI	MG	CR	HT	ZN	TI
0718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI  
TAIL ULTIMATE STRENGTH 11.0 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI  
HEAD ELONGATION (G.L. = 2 IN) 32 %  
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

\* AS REPORTED BY SUPPLIER  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-05

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
ASME SB269 1100 O, AMS 4001H 1100 O,  
ASTM B209-05 1100 O, AMS-00 A 250/1 1100 O  
PAX CERTS: 714-736-4040

\*\* END OF CERTIFICATION \*\*

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material and the composition. Also, note that a warranty is not a partial containment to aluminum alloys and neither a fee nor of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

This report is the property of Alcoa and is loaned to you for your use only. It is not to be distributed outside your organization. Reproduction of this report is prohibited.

Authorized Sign

JERRY KROBANY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature

12:52 FAX

0001-001



Sieg's Manufacturing Ltd.  
6236 205 street, Langley BC, V2Y 1N7  
Phone: (604) 530-7455 Fax: (604) 530-7490

## Packing Slip

Packing Slip No.: 34575  
Date: 11/05/2007  
Page: 1

<b>Sold to:</b>		<b>Ship to:</b>	
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	
<b>Order No.:</b> 4888		<b>Sold By:</b> KAULBARS, GERRY	
<b>Shipped By:</b>		<b>Ship Date:</b> 11/06/2007	
<b>Tracking No.:</b>			

Item No.	Unit	Description	Quantity
1	EACH	D2000109S OUTER FLANGE	10
2	EACH	D2000111S INNER CORE	10
REFERENCE ONLY			
Comment:			



**Sieg's Manufacturing Ltd.**

**Metal Spinning and Fabricating**

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

## INSPECTION REPORT

Date: Nov. 5/07  
Customer: Dart Aerospace  
Packing Slip: 34575

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	n/a	✓	<del>HR</del>
D2000111S	10	14G.	n/a.	✓	<del>HR</del>

7/11/07

S6

Notes:

2 Boxes.

Material Certification Attached: yes

**REFERENCE**